

Work Order ID 48669

July 2, 2009 8:46:21 AM



Page 1

Item ID: D350-607-041

Accept



Setup Start



Revision ID: F

Stop



Item Name: Heli-Utility-Basket, LH

Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/03/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D350-607

Rev F

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPPD350-607-041 CHG007

for CL 09/07/08

S 07/07/09 @

110

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

120

Small Fab

0.00



Small Fab

Small Fab

Memo

0.00

Assemble as per Dwg D350-607 ; Seal support gusset seam with white sikaflex-291 Batch: *MU1557* Expiry date: *10/01*

09-07-9

0

BL

Work Order ID 48669

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Page 2

Item ID: D350-607-041

Accept



Setup Start



Revision ID: F

Stop



Item Name: Heli-Utility-Basket, LH

Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/03/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

⇒ 8086769 @

QC

Memo

0.00

Quality Control

*****Ensure label for weight capacity is correct*****

140

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

Rev I

*

9/7/9 @

150

QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

⇒ 8086769 @

Work Order ID 48669

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Item ID: D350-607-041
Revision ID: F
Item Name: Heli-Utility-Basket, LH

Accept



Setup Start



Stop



Start Date: 7/15/09 Start Qty: 1.00
Required Date: 8/03/09 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-607-041 Location: Room I

7/17/09 SQ

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W 07-07-09

Picklist Print

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Page 1

Work Order ID: 48669

Parent Item: D350-607-041RevF

Parent Item Name: Heli-Utility-Basket, LH


Comments:

Start Date: 7/15/09


Required Date: 8/03/09

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-16A  Bolt	<i>12</i> <i>installs</i>	Purchased	No			120	Each	137.0000	2.0000	<i>2</i>	<i>9/7/8</i>	<i>SP</i>

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	137	
110915	37	<i>110915</i>
111965	100	

AN4-22A  Bolt	<i>12</i> <i>installs</i>	Purchased	No			120	Each	391.0000	1.0000	<i>1</i>	<i>9/7/8</i>	<i>SP</i>
--	---------------------------	-----------	----	--	--	-----	------	----------	--------	----------	--------------	-----------

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	391	
104937	8	
107715	5	
108483	178	<i>108483</i>
111965	200	

AN4-24A  Bolt	<i>12</i> <i>installs</i>	Purchased	No			120	Each	70.0000	1.0000	<i>1</i>	<i>9/7/8</i>	<i>SP</i>
--	---------------------------	-----------	----	--	--	-----	------	---------	--------	----------	--------------	-----------

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	70	
108255	20	<i>108255</i>
112082	50	

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Page 2

Work Order ID: 48669

Parent Item: D350-607-041RevF

Parent Item Name: Heli-Utility-Basket, LH



Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-7A <i># installed</i>		Purchased	No			120	Each	123.0000	2.0000			
												
Bolt												

9

9/7/8

54

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	123	
108077	3	
108928	2	
110155	18	
111668	100	

110155

AN5-17A <i># installed</i>	Purchased	No				120	Each	92.0000	4.0000			
												
Bolt												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	92	
102140	4	
107939	2	
108558	4	
110625	2	
111295	30	
111965	50	

111295

4

9/7/8

10 SP

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Shop Packet Print

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Work Order ID: 48669

Parent Item: D350-607-041RevF

Parent Item Name: Heli-Utility-Basket, LH

Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416		Purchased	No			120	Each	8,171.000	2.0000			



Washer

4 mont

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 8171

102929 2

105906 4

107321 23

107939 114

108161 553

108827 59

109249 69

110523 340

111279 2007

111916 5000

16941 0

AN960JD416L

instaler

Purchased

No

120

Each

726.0000

2.0000



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 726

107008 54

108138 4

108583 42

110153 626

(2) 9/1/8 SP

111279

(2) 9/1/8 SP

110153

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Work Order ID: 48669

Parent Item: D350-607-041RevF

Parent Item Name: Heli-Utility-Basket, LH

Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516 Washer	installed	Purchased	No			120	Each	1,603.000	4.0000		9/7/8	SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1603	
100564	2	
106167	6	
107534	34	
107959	43	
108246	46	
108672	2	
109059	49	
109752	22	
110363	46	
110523	57	
111279	296	
112082	1000	

111279

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Work Order ID: 48669

Parent Item: D350-607-041RevF

Parent Item Name: Heli-Utility-Basket, LH

Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD8 Washer		Purchased	No			120	Each	1,143.000	2.0000			

② 9/7/8 SP

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	1143	
107091	9	
108335	11	
110382	48	
110917	75	
111578	1000	

AN970-4 Washer		Purchased	No			120	Each	128.0000	4.0000			
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111578

9/7/8 ④ SP

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	128	
104885	3	
107242	3	
107715	1	
108077	2	
108377	19	
111724	3	
112082	97	

D2022-101 Spacer		Manufactured	No			120	Each	0.0000	2.0000			
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112082

45885

② 9/7/8 QD SP

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Work Order ID: 48669

Parent Item: D350-607-041RevF

Parent Item Name: Heli-Utility-Basket, LH



Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2221RevH 	instaler	Manufactured	No			120	Each	0.0000	1.0000			
350 Basket Base D2258-200RevC 	instaler	Manufactured	No			120	Each	22.0000	1.0000			
Placard 2001b												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 22
46323 2
48350 20


Amount

D2332-041RevC1 	instaler	Manufactured	No			120	Each	7.0000	1.0000			
Lid Prop Assembly 6.69" long												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 7
48351 7

D2512RevE 	instaler	Manufactured	No			120	Each	0.0000	1.0000			
Basket Lid 205/350												

48669B 09-07-9

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Shop Packet Print

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Picklist Print

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Work Order ID: 48669

Parent Item: D350-607-041RevF

Parent Item Name: Heli-Utility-Basket, LH

Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2530RevB *installed* Manufactured No



Handle Weldment

about

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 13

45683 3

48231 10

D2535RevA *installed* Manufactured No



Spring

about

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 99

46580 99

D2537RevA1 *installed* Manufactured No



Bushing

about

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 45

45662 5

48532 40

13.0000



99.0000



45.0000



9/7/8 54

(1)

45683

(2)

9/7/8

54

46580

(2)

9/7/8

54

45662

Picklist Print

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Work Order ID: 48669

Parent Item: D350-607-041RevF

Parent Item Name: Heli-Utility-Basket, LH



Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2728-3RevB 	<i>instaler</i>	Manufactured	No			120	Each	0.0000	0.0000			
Dart Logo label												
D2931RevA 	<i>instaler</i>	Manufactured	No			120	Each	1,005.000	2.0000			
Bumper												

② 22558 9/7/8 54

② 21139 9/7/8 54

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 1005
21139 5
46064 1000

Atout small FAB

MS20600-AD4W3 *instaler* Purchased No

Cherry Rivets

② 9/7/8 54

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 2793
102929 37
104715 10
106375 746
107939 1000
111636 1000

106375

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Work Order ID: 48669

Parent Item: D350-607-041RevF

Parent Item Name: Heli-Utility-Basket, LH


Comments:

Start Date: 7/15/09


Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3  Nut	instaleo	Purchased	No			120	Each	1,873.000	2.0000		9/1/8	SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1873	
110844	34	
111274	839	111274
111668	1000	

MS21042L4  Nut	instaleo	Purchased	No			120	Each	9,086.000	4.0000		9/1/8	SP
---	----------	-----------	----	--	--	-----	------	-----------	--------	--	-------	----

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	9086	
107499	5	
110507	2902	110507
111827	6000	
15924	0	
8182	179	

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Picklist Print

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Work Order ID: 48669

Parent Item: D350-607-041RevF

Parent Item Name: Heli-Utility-Basket, LH

Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-12A x5 Purchased



Bolt

150 Each 199.0000 5.0000



(5x)

9/1/8

50

5-
About PK

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

199

111605

99

111925

100

150

Each

1,164.000 8.0000



1111605

(8x)

9/1/8

1050

AN4-15A x5 (DSI 9380) Purchased



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1164

107737

8

108077

1

108868

7

109148

18

110399

130

111295

1000

110399

5-
About PK

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Work Order ID: 48669

Parent Item: D350-607-041RevF

Parent Item Name: Heli-Utility-Basket, LH

Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2230-3RevF

Manufactured

No

150

Each

237.0000

4.0000

4x 9/7/8 ~ SP



Lug About PK

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

237

22121

0

47965

134

48384

103

47965

D2324RevC

Manufactured

No

150

Each

17.0000

1.0000

9/7/8 SV



Strut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

17

47563

17

47563

D2732RevB1

Manufactured

No

150

f

532.1200

2.0000

3 inches 9/7/8 SD



Rubber Extrusion

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

532.12

38509

32.12

43118

500

93118

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Work Order ID: 48669

Parent Item: D350-607-041RevF

Parent Item Name: Heli-Utility-Basket, LH

Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042LS

Purchased

No

150

Each

791.0000

4.0000

(4)

9/7/8

1050

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

791

110382

10

111127

281

111636

500

111127

S =>

MS21042 L4

nuts

B4

1110507

+B

9/7/9 50

09/07/09

qty: 13

Date: Friday, 19/06/2009 11:19:29 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI UTILITY BASKET LH/RH
Job Number : 48669	
Estimate Number : 10197	
P.O. Number :	Part Number : D350607041
This Issue : 19/06/2009 S.O. No. :	Drawing Number : D350-607 REV F P7-9
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : F
Previous Run : 48667	Material :
Written By :	Due Date : 26/06/2009 Qty: 1 Um: Each
Checked & Approved By : <u>MF 09-06-19</u>	
Comment : Est Rev:M 05.09.02 Added D2856-400-720 KJ/JLM Est Rev:N 07-12-21 ECN1068 DD est Rev P 09.06.04 CHG 008 ecn 09-574 EC verified by:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	✓ DC	DOCUMENT CONTROL
-----	------	------------------



Comment: DOCUMENT CONTROL
 Photocopy bluefile & type labels per PPPD350-607-041 CHG008

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

3.0	✓ 48669A	BASKET BASE ASSEMBLY (350)
-----	----------	----------------------------



Comment: Sub-Component BASKET BASE ASSEMBLY (350)
 1 x D2221 Batch _____

4.0	✓ 48669B	350/212/130 BASKET LID
-----	----------	------------------------



Comment: Sub-Component 350/212/130 BASKET LID
 1 x D2512 Batch _____

5.0	✓ D2022101	Spacer
-----	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2	D2022-101	Spacer	_____
---	-----------	--------	-------

Date: Friday, 19/06/2009 11:19:29 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 48669

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

✓ D2258200

Placard 200lb



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2258-200 Label

7.0

✓ D2332041

Lid Prop Assembly 6.69" long



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass'y

8.0

✓ D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment

9.0

✓ D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring

10.0

✓ D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing

11.0

✓ D27283

Dart Logo label



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2728-3 Label

Date: Friday, 19/06/2009 11:19:29 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 48669

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0



D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2931 Bumper

13.0



AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN3-16A Bolt

14.0



AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN4-7A Bolt

15.0



AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN4-22A Bolt

16.0



AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN4-24A Bolt

17.0



AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN5-17A Bolt

Date: Friday, 19/06/2009 11:19:29 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 48669

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0



AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD8 Washer

19.0



AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416 Washer

20.0



AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416L Washer

21.0



AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer

22.0



AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer

23.0



MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS20600AD4W3 Rivet

Date: Friday, 19/06/2009 11:19:29 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 48669

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0



MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) _____

25.0



MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4) _____

26.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L5 Nut (or -5) _____

27.0



SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D350-607

Seal support gusset seam with white sikaflex-291 Batch: _____

Expiry date: _____

28.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*****Ensure label for weight capacity is correct*****

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

Date: Friday, 19/06/2009 11:19:29 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 48669

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0



D22301

Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-1

Lug

31.0



D22303

Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-3

Clamp

32.0



D2324

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 *D2324-1

Strut Ass'y

33.0



D2732

Rubber Extrusion



Comment: Qty.: 2.0000 f(s)/Unit Total : 2.0000 f(s)

Rubber Extrusion

8x D2732-030 (cut to 3")

Batch:

34.0



AN412A

Bolt



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

5 AN4-12A

Bolt

35.0



AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN4-15A

Bolt

Date: Friday, 19/06/2009 11:19:29 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 48669

Part Number: D350607041

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0



AN960JD416

Washer



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

26 AN960JD416

Washer

37.0



MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

13 MS21042L4

Nut (or -4)

38.0



QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

39.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-607-041

Location: _____

40.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

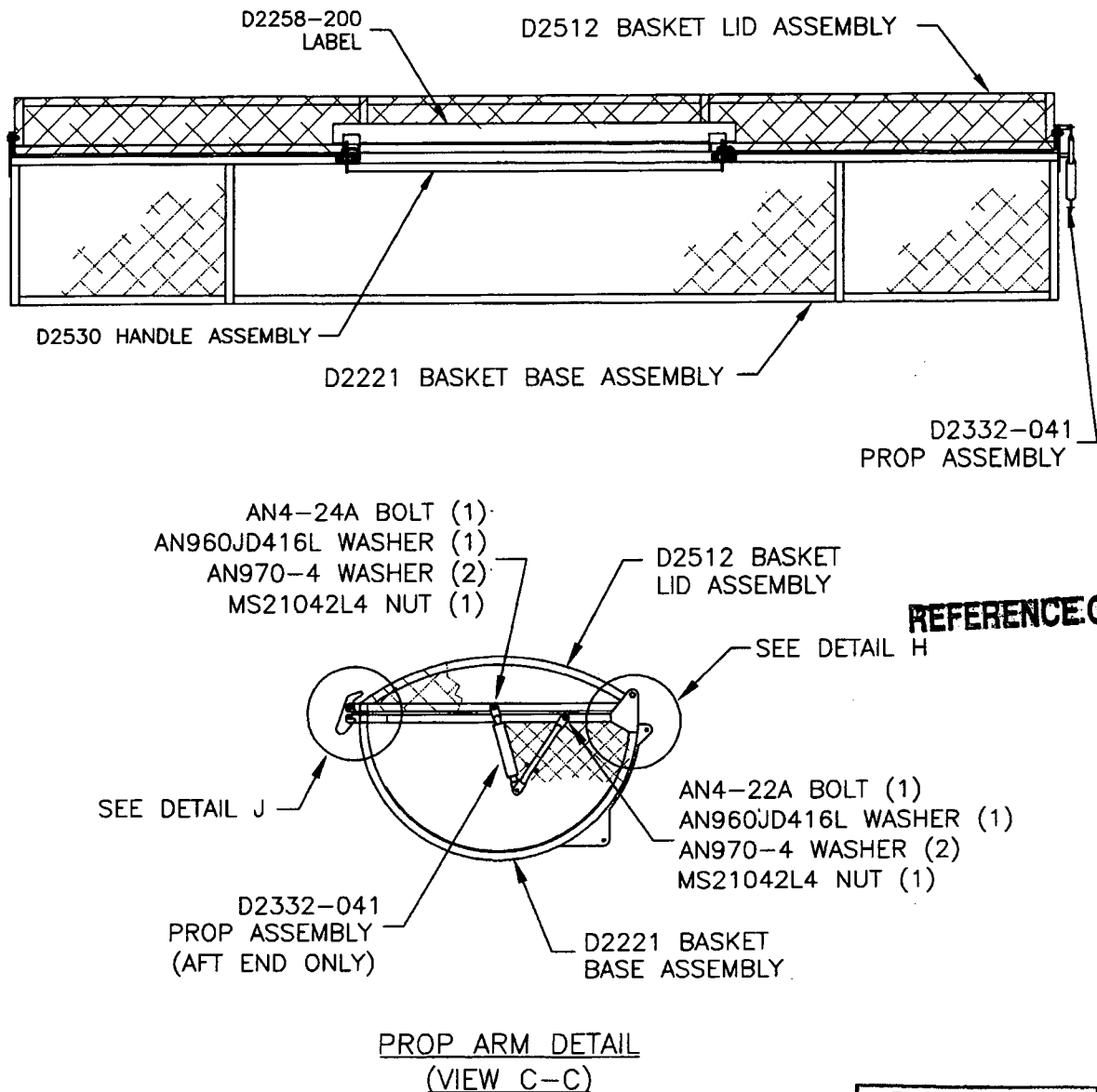


Figure 25-3 – Basket Replacement Parts
(D350-607-041 Heli-Utility-Basket™)

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TC Accepted
MAY 27 2003

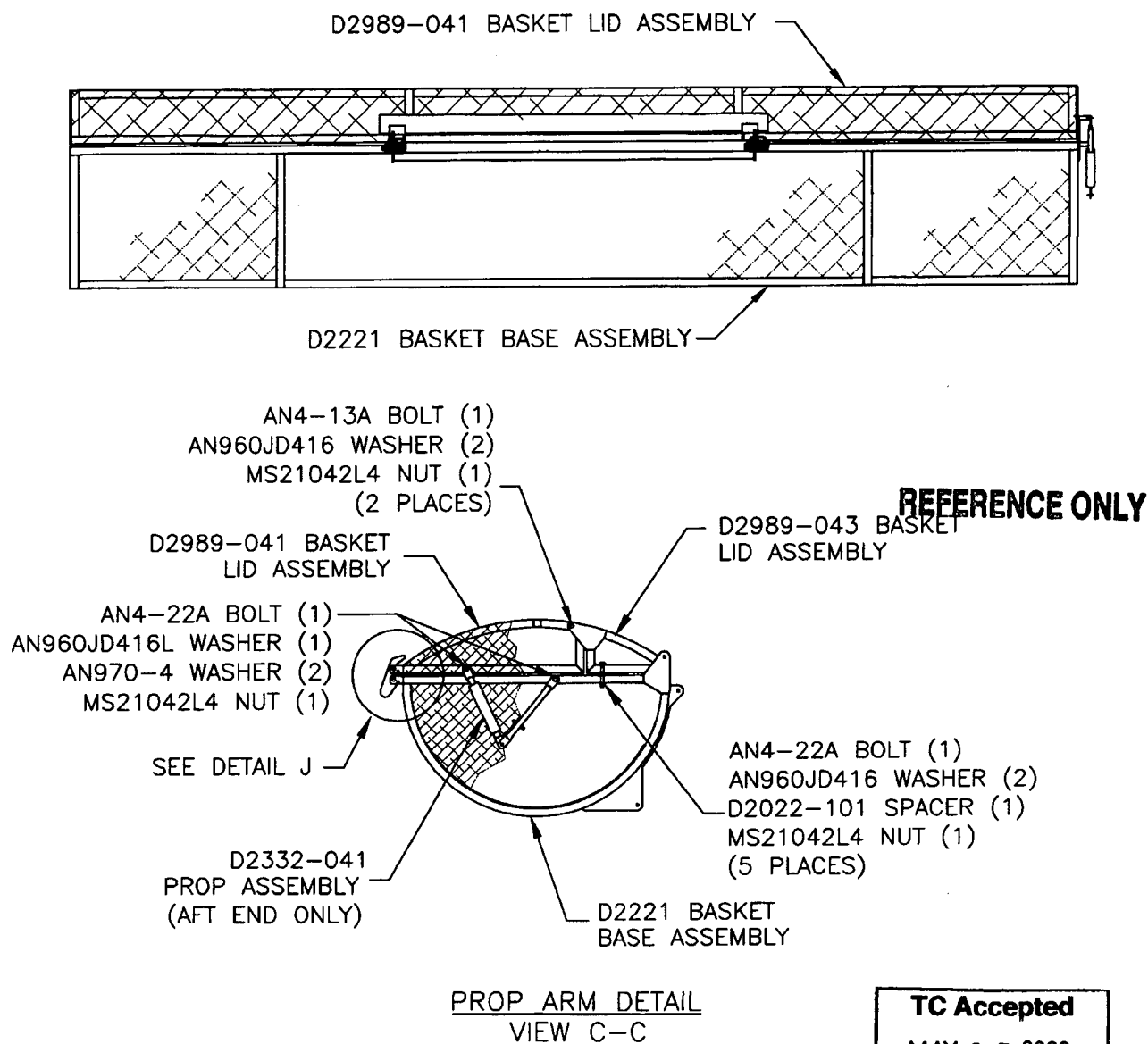
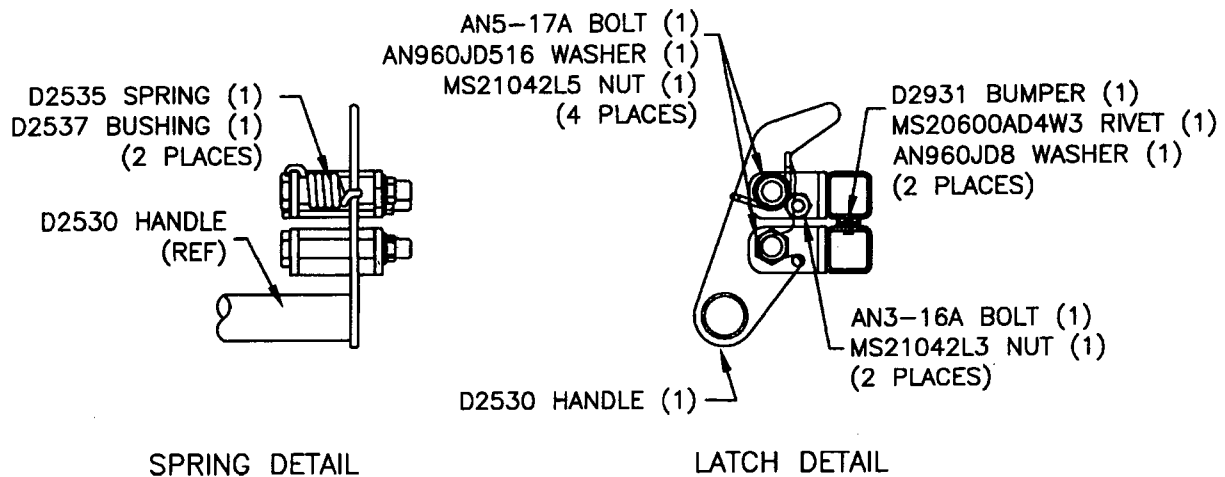


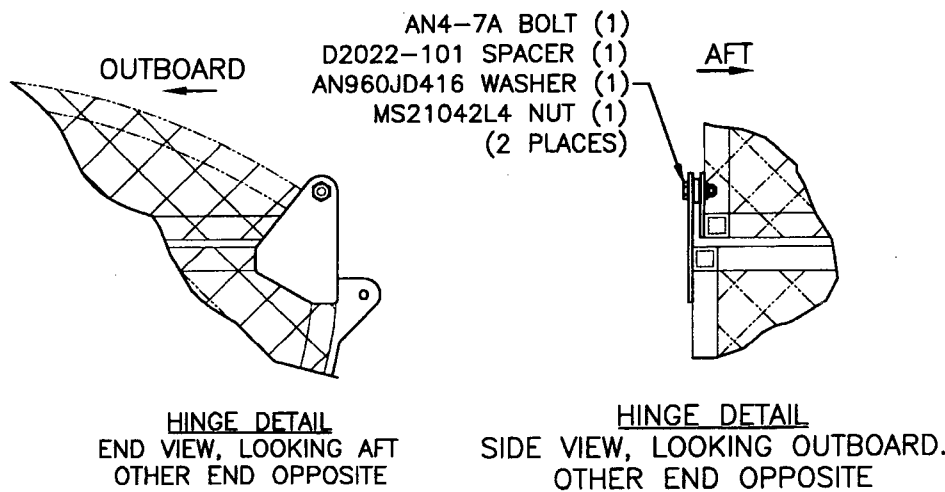
Figure 25-4 – Basket Replacement Parts
(D350-607-043 Heli-Utility-Basket™)

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DETAIL J:
HANDLE WELDMENT

REFERENCE ONLY



DETAIL H:
HINGE

Figure 25-5 – Basket Replacement Parts

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Revision: 0

TC Accepted

MAY 27 2003

25-00-00

Page 11 (12 blank) of 16

Status	Item ID	Rev	Name	Start Date	Quantity	UOM	Prop Date	Secrap	ap	Quamme	nd	NEC	ILCX	ISortime	Offsetan	Ty 1	Per	Och	to	wore	Ce	Last	Mdd	Dat
✓	AN4-24A		Bolt	1/01/08	1.0...	Ea	110	0...	0.0...					13	0	M...					7/0...	6/0...		
✓	D2535	A	Spring	1/01/08	2.0...	Ea	110	0...	0.0...					7	0	M...					7/0...	6/0...		
✓	D2221	H	350 Basket Base	1/01/08	1.0...	Ea	110	0...	0.0...					1	0	M...					7/0...	6/0...		
✓	D2537	A1	Bushing	1/01/08	2.0...	Ea	110	0...	0.0...					7	0	M...					7/0...	6/0...		
✓	AN960JD416L		Washer	1/01/08	2.0...	Ea	110	0...	0.0...					16	0	M...					7/0...	6/0...		
✓	AN3-16A		Bolt	1/01/08	2.0...	Ea	110	0...	0.0...					10	0	M...					7/0...	6/0...		
✓	AN960JD416		Washer	1/01/08	2.0...	Ea	110	0...	0.0...					15	0	M...					7/0...	6/0...		
✓	AN960JD516		Washer	1/01/08	4.0...	Ea	110	0...	0.0...					17	0	M...					7/0...	6/0...		
✓	AN960JD8		Washer	1/01/08	2.0...	Ea	110	0...	0.0...					13	0	M...					7/0...	6/0...		
✓	D2512	E	Basket Lid 205/350	1/01/08	1.0...	Ea	110	0...	0.0...					2	0	M...					7/0...	6/0...		
✓	D2022-101		Spacer	1/01/08	2.0...	Ea	110	0...	0.0...					3	0	M...					7/0...	6/0...		
✓	AN5-17A		Bolt	1/01/08	4.0...	Ea	110	0...	0.0...					14	0	M...					7/0...	6/0...		
✓	AN4-22A		Bolt	1/01/08	1.0...	Ea	110	0...	0.0...					12	0	M...					7/0...	6/0...		
✓	D2931	A	Bumper	1/01/08	2.0...	Ea	110	0...	0.0...					9	0	M...					7/0...	6/0...		
✓	MS21042L3		Nut	1/01/08	2.0...	Ea	110	0...	0.0...					20	0	M...					7/0...	6/0...		
✓	D2332-041	C1	Lid Prop Assembly...	1/01/08	1.0...	Ea	110	0...	0.0...					5	0	M...					7/0...	6/0...		
✓	D2258-200	C	Placard 200lb	1/01/08	1.0...	Ea	110	0...	0.0...					4	0	M...					7/0...	6/0...		
✓	MS21042L5		Nut	1/01/08	4.0...	Ea	110	0...	0.0...					22	0	M...					7/0...	6/0...		
✓	D2530	B	Handle Weldment	1/01/08	1.0...	Ea	110	0...	0.0...					6	0	M...					7/0...	6/0...		
✓	MS21042L4		Nut	1/01/08	4.0...	Ea	110	0...	0.0...					21	0	M...					7/0...	6/0...		
✓	AN4-7A		Bolt	1/01/08	2.0...	Ea	110	0...	0.0...					11	0	M...					7/0...	6/0...		
✓	MS20600-AD4W3		Cherry Rivets	1/01/08	2.0...	Ea	110	0...	0.0...					19	0	M...					7/0...	6/0...		
✓	AN970-4		Washer	1/01/08	4.0...	Ea	110	0...	0.0...					18	0	M...					7/0...	6/0...		
✓	D2728-3	B	Dart Logo label	1/01/08	0.0...	Ea	110	0...	0.0...					8	0	M...					7/0...	6/0...		
✓	AN4-15A		Bolt	1/01/08	8.0...	Ea	140	0...	0.0...					27	0	M...					7/0...	6/0...		
✓	AN960JD416		Washer	1/01/08	26...	Ea	140	0...	0.0...					28	0	M...					7/0...	6/0...		
✓	D2230-3	F	Lug	1/01/08	4.0...	Ea	140	0...	0.0...					24	0	M...					7/0...	6/0...		
✓	AN4-12A		Bolt	1/01/08	5.0...	Ea	140	0...	0.0...					26	0	M...					7/0...	6/0...		
✓	D2230-1	F	Lug	1/01/08	4.0...	Ea	140	0...	0.0...					23	0	M...					7/0...	6/0...		
✓	D2732	B1	Rubber Extrusion	1/01/08	2.0...	f	140	0...	0.0...					26	0	M...					7/0...	6/0...		

Status	Item ID	Rev	Name	Start Date	Quantity	UOM	Op Date	Sec	rap	ap	Qua	mm	nd	NEC	IECX	ISort	ime	Offset	an	Ty 1	Per	O'ch	to	More	Cie	Last	Add	Dat
✓	MS21042L4		Nut	7/09/09	13....	Ea		140	0...	0.0...						29		0	M...							7/0...	7/0...	
✓	D2324 ✓	C	Strut	1/01/08	1.0...	Ea		140	0...	0.0...						25		0	M...							7/0...	6/0...	

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-607-041/-043 (LH installation)	88 lb 39.9 kg	- 48 in - 1.22 m	- 4224 in-lb - 48.7 m-kp	135 in 3.43 m	-11880 in-lb -136.9 m-kp
D350-607-041/-043 (RH installation)	88 lb 39.9 kg	+ 48 in + 1.22 m	+ 4224 in-lb + 48.7 m-kp	135 in 3.43 m	11880 in-lb 136.9 m-kp

5. PARTS LIST

Qty -041	Qty -043	Part Number	Description
X		D350-607-041	HELI-UTILITY-BASKET
	X	D350-607-043	HELI-UTILITY-BASKET
2	5	D2022-101	SPACER
1	1	D2221	BASKET BASE ASSEMBLY
4	4	D2230-1	LUG
4	4	D2230-3	CLAMP
1	1	D2258-200	LABEL
1	1	D2324	STRUT
1	1	D2332-041	PROP ASSEMBLY
1		D2512	BASKET LID ASSEMBLY
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
2	2	D2537	BUSHING
4	4	D2856-400-720	ABRASION STRIP
2	2	D2931	BUMPER
1		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
1		D2989-043	BASKET LID ASSEMBLY (INSIDE)
2	2	AN3-16A	BOLT
2		AN4-7A	BOLT
5	5	AN4-12A	BOLT
8	10	AN4-13A	BOLT
1	7	AN4-22A	BOLT
1		AN4-24A	BOLT
4	4	AN5-17A	BOLT
2	2	MS20600AD4W3	RIVET (OR CR9163-4-3)
28	40	AN960JD416	WASHER
2	2	AN960JD416L	WASHER
4	4	AN960JD516	WASHER
2	2	AN960JD8	WASHER
4	4	AN970-4	WASHER
2	2	MS21042L3	NUT (OR MS21042-3)
17	22	MS21042L4	NUT (OR MS21042-4)
4	4	MS21042L5	NUT (OR MS21042-5)

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND DRAWING D350-607 REV. F

REF CANADIAN STC: SH94-14

FAA STC: SR00213NY

FOR THE FOLLOWING D350-607-XXX HELI-UTILITY-BASKET INSTALLATIONS, INSTALL THE D2732-030 RUBBER CUSHIONS UNDER THE D2230-1/-3 CLAMPS AS SHOWN IN FIGURE 1. THE D2856-400-720 ABRASION STRIPS HAVE BEEN REMOVED FROM THE D350-607-XXX HELI-UTILITY-BASKET KITS.

TABLE 1: D350-607-XXX KITS WITH D2732-030 RUBBER CUSHION

INSTALLATION	CHG NUMBER
D350-607-041	007 OR LATER
D350-607-043	004 OR LATER
D350-607-045	002 OR LATER
D350-607-047	002 OR LATER

REFERENCE ONLY

AMEND PARTS LIST AS FOLLOWS:

REMOVE:

Qty -041	Qty -043	Qty -045	Qty -047	PART NUMBER	DESCRIPTION
X				D350-607-041	HELI-UTILITY-BASKET
	X			D350-607-043	HELI-UTILITY-BASKET
		X		D350-607-045	HELI-UTILITY-BASKET
			X	D350-607-047	HELI-UTILITY-BASKET
4	4	4	4	D2856-400-720	ABRASION STRIP
8	8*	8	8*	AN4-13A	BOLT

*NOTE: FOR D350-607-043/-047 INSTALLATIONS, QTY (2) AN4-13A BOLTS USED FOR INSTALLATION OF THE SPLIT LID ARE STILL INCLUDED

ADD:

Qty -041	Qty -043	Qty -045	Qty -047	PART NUMBER	DESCRIPTION
X				D350-607-041	HELI-UTILITY-BASKET
	X			D350-607-043	HELI-UTILITY-BASKET
		X		D350-607-045	HELI-UTILITY-BASKET
			X	D350-607-047	HELI-UTILITY-BASKET
8	8	8	8	D2732-030	RUBBER CUSHION
8	8	8	8	AN4-15A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 07.11.14
CERT. NO.: SH94-14
ISSUE NO.: 4

B	D2732-030 IS NOW STANDARD ON -041/-043/-045/-047; DSI 9380-011 UPGRADE OPTION FOR PREVIOUS CUSTOMERS	PH	07.11.14
A	NEW ISSUE	MB	07.06.06
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9380	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		RUBBER CUSHION KIT	NTS
DATE	07.11.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

FOR CUSTOMERS WHO WOULD LIKE TO UPGRADE THEIR D350-607-041/-043/-045/-047 HELI-UTILITY-BASKET TO HAVE THE D2732-030 RUBBER CUSHION, THE FOLLOWING KIT CAN BE OBTAINED FROM DART:

DSI 9380-011 PARTS LIST

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9380-011	RUBBER CUSHION KIT
8	D2732-030	RUBBER CUSHION
8	AN4-15A	BOLT
16	AN960JD416	WASHER
8	MS21042L4	NUT (OR MS21042-4)

REFERENCE ONLY

NOTE: REMOVE THE D2856-400-720 ABRASION STRIP PER SECTION 25.5 OF ICA-D350-607 PRIOR TO INSTALLING THE D2230-1/-3 CLAMPS WITH THE D2732-030 RUBBER CUSHIONS.

*ACCEPTABLE TO USE LONGER/SHORTER AN4 BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960JD416 WASHERS UNDER NUT TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

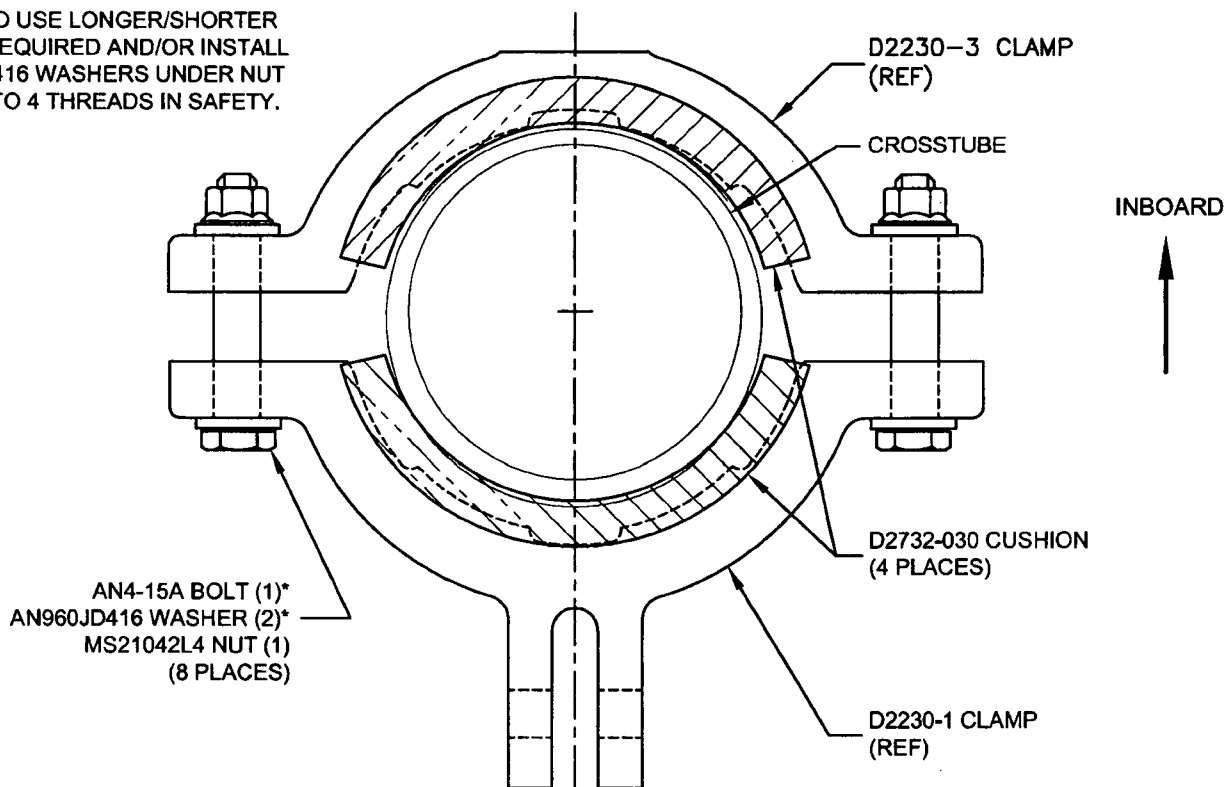


FIGURE 1 - D2732-030 RUBBER CUSHION INSTALLATION
(4 PLACES PER INSTALLATION)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 07.11.14
CERT. NO.: SH94-14
ISSUE NO.: 4

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9380	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RUBBER CUSHION KIT	NTS
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DART SERVICE INSTRUCTION

TO AMEND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607

REF. CANADIAN STC: SH94-14

REF. FAA STC: SR00213NY

REF. EASA STC: EASA.IM.R.S.01405

REFERENCE ONLY

IN CASES WHERE THE D2325 GUSSETS HAVE SUSTAINED CONSIDERABLE DAMAGE, DSI 9342-011/-013 REPAIR KITS CAN BE PROCURED FROM DART TO REWORK EXISTING D350-607-041/-043 BASKET BASES ONLY. D350-607-045/-047 BASKET BASES CANNOT BE REWORKED TO THIS PROCEDURE. REPLACE THE D2325 GUSSETS BY T.I.G. WELDING AS FOLLOWS:

- 1) CLEAN AREA OF PAINT, ETC...
- 2) REMOVE EXISTING D2325 GUSSET(S) AS SHOWN IN FIGURE 1.
- 3) INSTALL REPLACEMENT D3929-041/-042 GUSSETS BY T.I.G. WELDING PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L FILLER ROD AS SHOWN IN FIGURE 2.
- 4) TOUCH UP PAINT IN ACCORDANCE WITH ICA-D350-607 REV 0.
- 5) WHEN BASKET BASE IS REPAIRED, LONGER BOLTS OR QUICK RELEASE PINS ARE REQUIRED TO INSTALL THE BASKET ON AIRCRAFT. SUBSTITUTE EXISTING HARDWARE USING PARTS LISTED BELOW.
- 6) ADJUST WEIGHT AND BALANCE IN ACCORDANCE WITH THE TABLE ON SHEET 4.






PARTS LIST

QTY. -011	QTY. -013	PART NUMBER	DESCRIPTION
X		DSI 9342-011	GUSSET REPAIR KIT
	X	DSI 9342-013	GUSSET REPAIR KIT, QUICK RELEASE
2	2	D3929-041	GUSSET ASSY, LH
2	2	D3929-042	GUSSET ASSY, RH
4		AN4-15A	BOLT (REPLACES AN4-12A)
8		AN960JD416	WASHER
	4	BLRS-020	QUICK RELEASE PIN (REPLACES BLRS-010)
4		MS21042L4	NUT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 09.04.06
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